

Date: Tuesday, 12/5/2006 8:14:36 AM
 User: Kim Johnston

Process Sheet

SPLIT-1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (19"X24")
Job Number	: 29771		
Estimate Number	: 10972		
P.O. Number	: N/A	Part Number	: D130700011
This Issue	: 12/5/2006	S.O. No. :	N/A
Prsht Rev.	: NC	Drawing Number	: D3167 REV A1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 24974	Drawing Revision	: A1
		Material	: N/A
Written By	:	Due Date	: 12/23/2006
Checked & Approved By	:	Qty:	5 Um: Each
Comment	: Est Rev:J 04.02.17 Blank size changed KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D130-700-011CHG001

K.S. 06.12.08

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 6.9975 sf(s)/Unit Total: 34.9876 sf(s)

blank: 20.00" x 24.00" x 1.00" thick (+0.030/-0.000)

Material: Black UHMW 1"

(MUHMWB10)

Batch: M 103315

J.F. 07/02/11

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA285 and Dwg D3167

3-Deburr

J.F. 07/02/11

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/02/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:14:36 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 29771

Part Number: D130700011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 07/02/12 (X5K1)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7/2/21 (5)

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 2.0000 f(s)/Unit Total : 10.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B060

Rubber Cushion

330397

✓

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274

Radius Block

330380

✓

2 D2432F(ref only)

Bearpaw

329771

9.0

D2519

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2519

Clamp

326216

✓

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529

Washer

326485 50x

328733 10x

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 29771

Part Number: D130700011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D31711

Angle



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D3171-1 Angle 318591 /

12.0

AN412A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

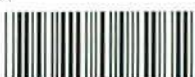
Qty Part Number Description Batch

4 AN4-12A Bolt M6071 8X M9599 12X

13.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A Bolt M103585 ✓

14.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer M103338 ✓

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4) M103349 ✓

677/21 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 22 Date: 07/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:14:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 29771

Part Number: D130700011

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D130-700-011

Location: A

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07/02/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29771
Description: Bearpaw		Part Number:	D3167-1
Inspection Dwg: D3167	Rev: A1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.06 x 45°	+0.030/-0.010	0.50" x 45°	✓		
B	5.80	+/-0.030	5.787"	✓		
C	0.25 x 45°	+/-0.030	280" x 45°	✓		
D	R0.25	+/-0.030	R0.25"	✓		
E	0.200	+/-0.030	.205"	✓		
F	0.250	+/-0.010	.240"	✓		
G	0.625	+/-0.030	.615"	✓		
H	0.375	+/-0.010	.365"	✓		
I	0.950	+0.030/-0.010	.940"	✓		
J	3.21	+/-0.030	3.200"	✓		
K	19.00	+/-0.030	19.00"	✓		
L	Ø0.260	+0.005/-0.000	Ø.259"	✓		
M	Ø0.93	+/-0.030	Ø.931"	✓		
N	0.30	+0.030/-0.000	.330"	✓		
O	0.375	+/-0.030	.377"	✓		
P	7.23	+/-0.030	7.219"	✓		
Q	4.54	+/-0.010	4.539"	✓		
R	2.00	+/-0.030	1.998"	✓		
S	12.000	+/-0.010	12.000"	✓		
T	6.000	+/-0.010	6.000"	✓		
U	23.75	+/-0.030	23.750"	✓		

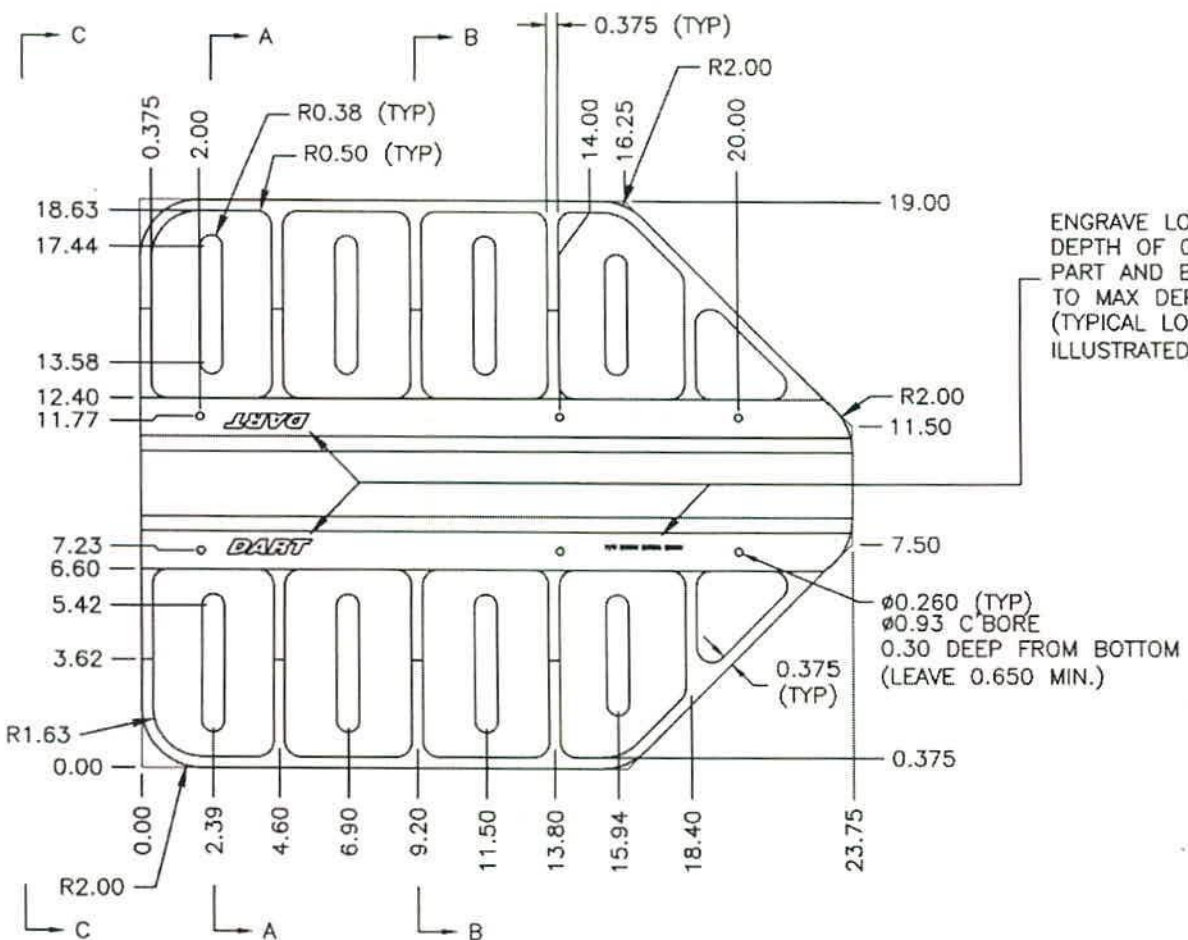
Measured by: J.F.	Audited by: J.A.	Prototype Approval:	N/A
Date: 07/02/11	Date: 07.02.11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	P/O D130-700-011	KJ/RF

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3167	SHEET 1 OF 2
02.10.08		TITLE	SCALE
		BEARPAW	1:6
A	02.10.08	NEW ISSUE	
A1	02.12.17	5.80 WAS 5.50	

RELEASED
02-10-25-11

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)



D3167-1

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1.00
TOLERANCES ARE
SHOP COPY
RETURN TO
ENGINEER
CONTROLLED COPY
SUBMIT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29771

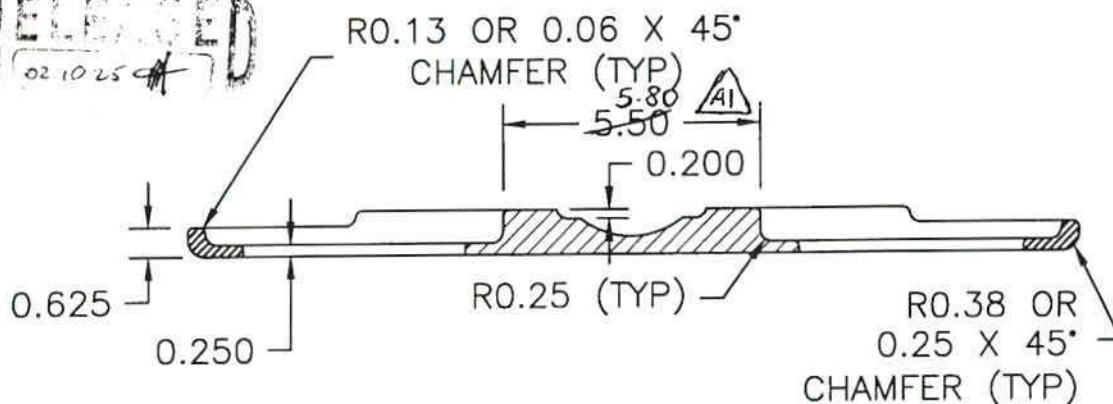
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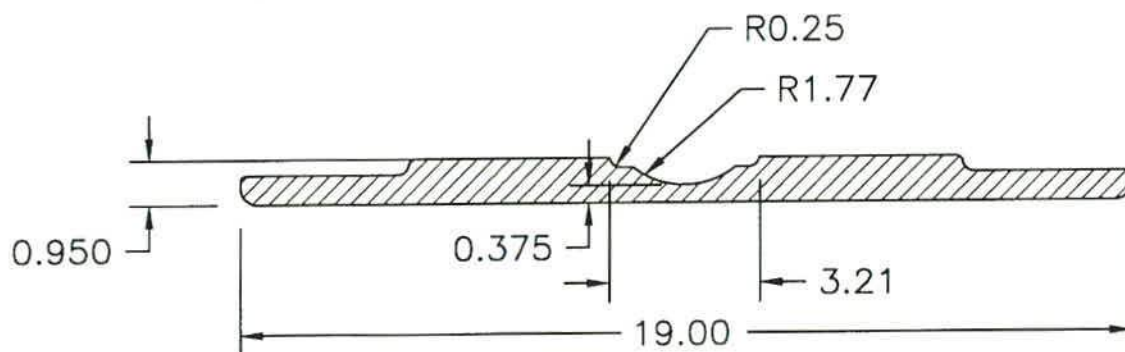
DART

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08	TITLE BEARPAW		SCALE 1:4

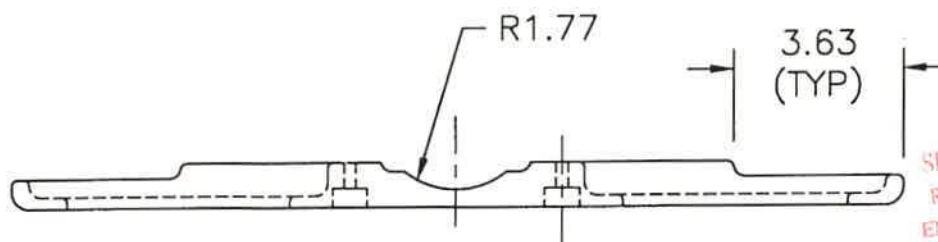
RELEASED
02.10.25



SECTION A-A



SECTION B-B



SECTION C-C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29771

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